

Date: Tuesday, 7/18/2006 2:53:23 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH UNDER REVIEW  
 Job Number : 27956  
 Estimate Number : 10262  
 P.O. Number : N/A Part Number : D350636011  
 This Issue : 7/18/2006 S.O. No. : N/A Drawing Number : D2750 UNDER REVIEW  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : D  
 Previous Run : 27955 Material : N/A  
 Due Date : 8/15/2006 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: 02-09-25 Rearranged procedure steps KJ  
 Est Rev:J 06-03-23 As per Rev D JLM  
 Est Rev:J 06-07-13 As per dsi9343 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 002

KS 00-0801 ①

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2600-3-Bent Extrusion (Bent) B26787

Pm 06-08-16 ①

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap:

Batch:

B25839

BE 06-08-16 ①

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8863 drilling holes labelled "A" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

Pm 06-08-16 ①

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
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| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
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|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes for Detail B using DT8330

5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" \*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\*

6-Open up holes of Detail A to 0.250" (total of 2 holes per side)

7- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

8-Countersink Detail A as per dwg D2750.

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod

10-Grind welds flush as per Dwg D2750

5.0

QC59

WELD INSPECTION



Comment: WELD INSPECTION

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch:

B27503 BE 6-8-17

9.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

B27385 BE 06-08-21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
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Seq. #:

Machine Or Operation:

Description :

10.0

D34903

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: *B 27973 BE 06-08-21*

11.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch: *B 26208 BE 06-08-21*

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750 .

2-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750.

3-Open up holes of Detail D to 0.750" (total of 4 holes per side) as per dwg D2750.

4-Chamfer holes of Detail V, Detail C, Detail D and hole size "W" per dwg D2750 (welding instructions on sheet 4)

5-Deburr and blow out all chips from inside of tube

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: *M101855*

exp. date: *06-07/02*

*BE 06-08-17*

7- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 4)

A/R

Aluminum Rod

batch: *M100660 / M101655*

*BE 06-08-21*

8-Grind welds flush as per Dwg D2750

*fm 06-08-23*

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750

*fm 06-08-23*

10-Deburr holes

*fm 06-08-23*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
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Seq. #:

Machine Or Operation:

Description :

13.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and work to Step 20

PD 06-08-23 (1)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

9.m 06-08-29 (1)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

DL 06/08/30 (1)

16.0

NAS1330S3KB166

INSERT



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

INSERT

Batch: M101483

DL 06/08/30 (1)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per Dwg D2750

DL 06/08/30 (1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

M 060830 (1)

19.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Wearpad

Batch: B27169-2

20.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B27074

DL 06/08/30 (1)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
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Job Number: 27956

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B25530

22.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B27485

23.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B26140 X 8

24.0

D3488041

BLADE FITTING ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B27197 B26838

25.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B27519 B27191

26.0

D3492043

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B27519

DL 06/08/30 (1)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
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Job Number: 27956

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: M101938

28.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: ~~M101124~~ M101291

29.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: 101124

30.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M19514

31.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M112180

32.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: M100186

33.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M110186

DL 06/08/30 (1)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
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Job Number: 27956

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Seq. #:

Machine Or Operation:

Description :

34.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: 1X M19185, 3X M101537

35.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: 100186

36.0

NAS1515H3L

WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

WASHER

Batch: M101340

37.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: M100187

DL 06/08/30 (1)

38.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

DL

06/08/22

2-Spray inside of tube with "LPS-3" batch: 101092

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 101855

EXP DATE: 02 07

DL 06/08/22

4-Coat all exposed fasteners with "LPS Procyon"

batch: 17168

DL 06/08/22

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
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39.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 06 10 16 ①

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

41.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch:

B23614 ✓ BATCH # NOT IN The computer system.

42.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch:

M100186 ✓

43.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch:

M100186 ✓

44.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch:

M100262 ✓

45.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch:

M100187 ✓

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   *DS*   Date: 06/10/17

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Description :

46.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: B27895

47.0

D35321

spacer



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)

batch: B27879

BOC 11/01/17 (1)

48.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

49.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

REV

REV 11/01/17 (1)

50.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/10/17 (1)

Job Completion



U 06.10.17

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



|                               |                                |   |                        |
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| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2750  | REV. D<br>SHEET 1 OF 5 |
| DATE<br>06.01.05              |                                | TITLE<br>350 SKIDTUBE ASSEMBLY<br>SCALE<br>NTS                          |                        |
| A                             | 98.04.16                       | NEW ISSUE   |                        |
| B                             | 98.09.01                       | CHANGE MS24694-S293 TO AN8-16A  |                        |
| C                             | 98.11.18                       | ADD D2750-3/D2750-4<br>INCORPORATE D2738 AND D2740                      |                        |
| D                             | 06.01.05                       | ADD HOLES AND SPACERS FOR<br>APICAL FLOATS<br>INCORPORATE DEO 9133/9157 |                        |

**RELEASED**  
06-02-07 *[Signature]*

| Qty<br>-041 | Qty<br>-042 | Qty<br>-043 | Qty<br>-044 | Part Number    | Description           |
|-------------|-------------|-------------|-------------|----------------|-----------------------|
| X           |             |             |             | D2750-041      | SKIDTUBE ASSEMBLY, LH |
|             | X           |             |             | D2750-042      | SKIDTUBE ASSEMBLY, RH |
|             |             | X           |             | D2750-043      | SKIDTUBE ASSEMBLY, LH |
|             |             |             | X           | D2750-044      | SKIDTUBE ASSEMBLY, RH |
| 5           | 5           | 5           | 5           | D2648-3        | WEARPAD               |
| 1           | 1           | 1           | 1           | D2656-13       | WEARSHOE              |
| 1           | 1           | 1           | 1           | D2656-35       | WEARSHOE              |
| 1           | 1           | 1           | 1           | D2746          | WEARSHOE              |
| 1           | 1           | 1           | 1           | D2739          | WEB                   |
| 1           | 1           | 1           | 1           | D2741          | BLADE                 |
| 8           | 8           | 8           | 8           | D2743          | SPACER                |
| 1           | 1           | 1           | 1           | D2744          | CAP                   |
| 8           | 8           | 8           | 8           | D2745          | BUSHING               |
| 1           |             |             |             | D2750-1        | SKIDTUBE WELDMENT, LH |
|             | 1           |             |             | D2750-2        | SKIDTUBE WELDMENT, RH |
|             |             | 1           |             | D2750-3        | SKIDTUBE WELDMENT, LH |
|             |             |             | 1           | D2750-4        | SKIDTUBE WELDMENT, RH |
| 1           |             | 1           |             | D3488-041      | BLADE FITTING, LH     |
|             | 1           |             | 1           | D3488-042      | BLADE FITTING, RH     |
| 4           | 4           | 4           | 4           | D3490-1        | SPACER                |
| 4           | 4           |             |             | D3490-3        | SPACER                |
|             |             | 4           | 4           | D3490-5        | SPACER                |
| 8           | 8           | 8           | 8           | D3492-041      | PLUG ASSEMBLY         |
| 8           | 8           |             |             | D3492-043      | PLUG ASSEMBLY         |
|             |             | 8           | 8           | D3492-045      | PLUG ASSEMBLY         |
| 38          | 38          | 38          | 38          | AN3C5A         | BOLT                  |
| 4           | 4           | 4           | 4           | AN3C6A         | BOLT                  |
| 4           | 4           | 4           | 4           | AN3C7A         | BOLT                  |
| 4           | 4           | 4           | 4           | AN6C44A        | BOLT                  |
| 2           | 2           | 2           | 2           | AN8C21A        | BOLT                  |
| 1           | 1           | 1           | 1           | AN8C35A        | BOLT                  |
| 46          | 46          | 46          | 46          | AN960C10L      | WASHER                |
| 4           | 4           | 4           | 4           | AN960C816L     | WASHER                |
| 4           | 4           | 4           | 4           | MS21043-6      | NUT                   |
| 3           | 3           | 3           | 3           | MS21083C8      | NUT                   |
| 42          | 42          | 42          | 42          | NAS1330S3KB166 | INSERT                |
| 46          | 46          | 46          | 46          | NAS1515H3L     | WASHER                |
| 12          | 12          | 12          | 12          | NAS1515H8L     | WASHER                |

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| CHECKED<br>H     | APPROVED<br>H  | DRAWING NO.<br>D2750                         | REV. D<br>SHEET 2 OF 5 |
| DATE<br>06.01.05 |                | TITLE<br>350 SKIDTUBE ASSEMBLY               | SCALE<br>NTS           |

RELEASED  
06.02.07

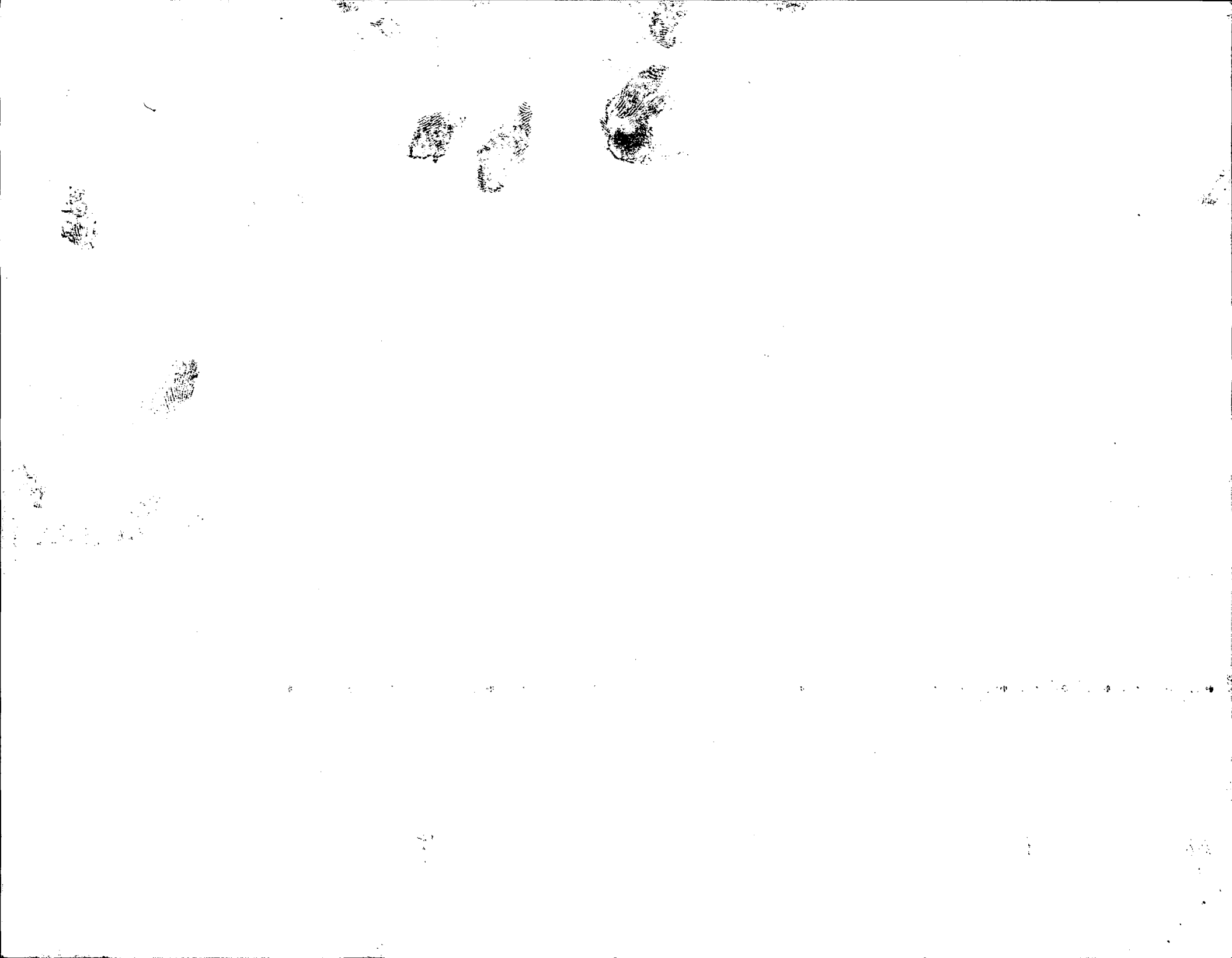
GENERAL NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ( $\emptyset 0.250$ -  $\emptyset 0.257$ ) FOR WEARSHOE INSERTS. C'SINK  $\emptyset 0.391 \times 100^\circ$  AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

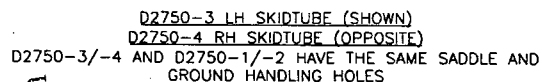
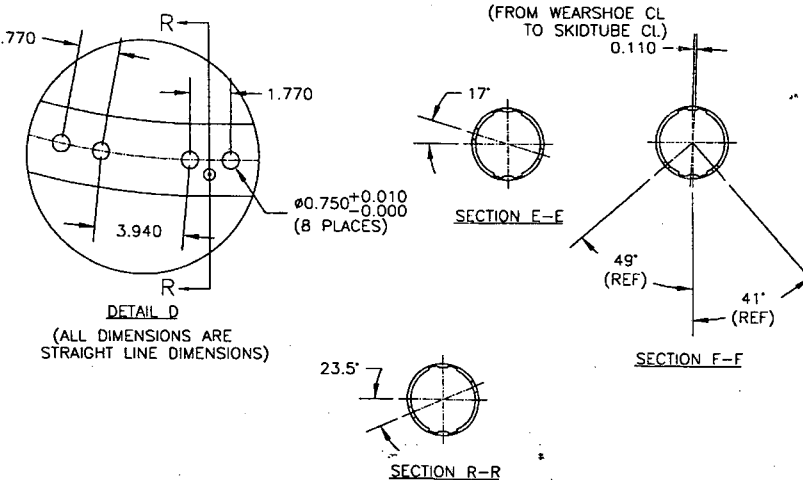
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
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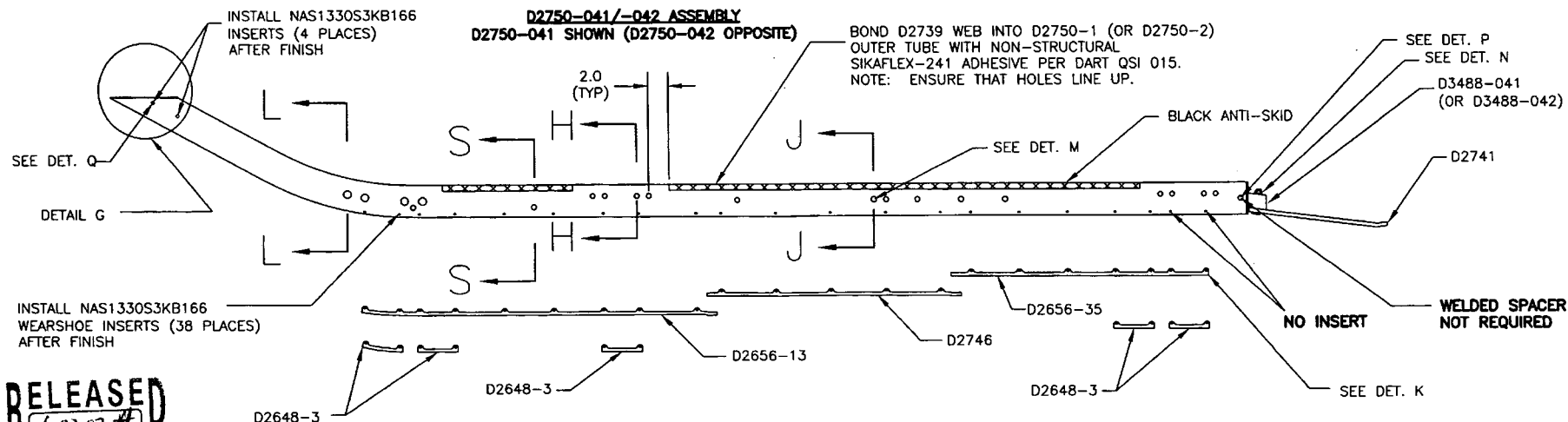
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| DATE<br>06.01.05   |  | TITLE<br>350 SKIDTUBE ASSEMBLY |                |   |                        |

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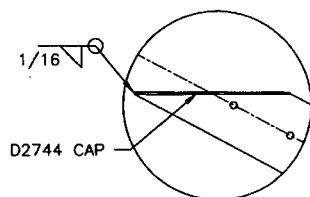
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06-02-07

**D2750-041/-042 ASSEMBLY**  
**D2750-041 SHOWN (D2750-042 OPPOSITE)**

BOND D2739 WEB INTO D2750-1 (OR D2750-2)  
OUTER TUBE WITH NON-STRUCTURAL  
SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.



DETAIL G



SECTION H-H



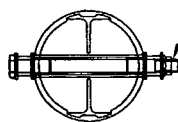
SECTION J-J



**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

DETAIL M



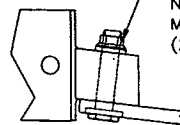
SECTION L-L

D3490-3 SPACER

Ø0.750 HOLES ONLY

D3492-043 PLUG ASSEMBLY

DETAIL N



SECTION S-S

D3490-1 SPACER

Ø0.500 HOLES ONLY

D3492-041 PLUG ASSEMBLY

**WELDING INSTRUCTIONS**

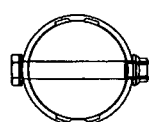
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

DETAIL K

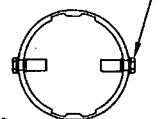


AN3C5A BOLT (1)  
AN960JD10L WASHER (1)  
NAS1515H3L WASHER (1)  
(38 PLACES)

DETAIL P



DETAIL Q



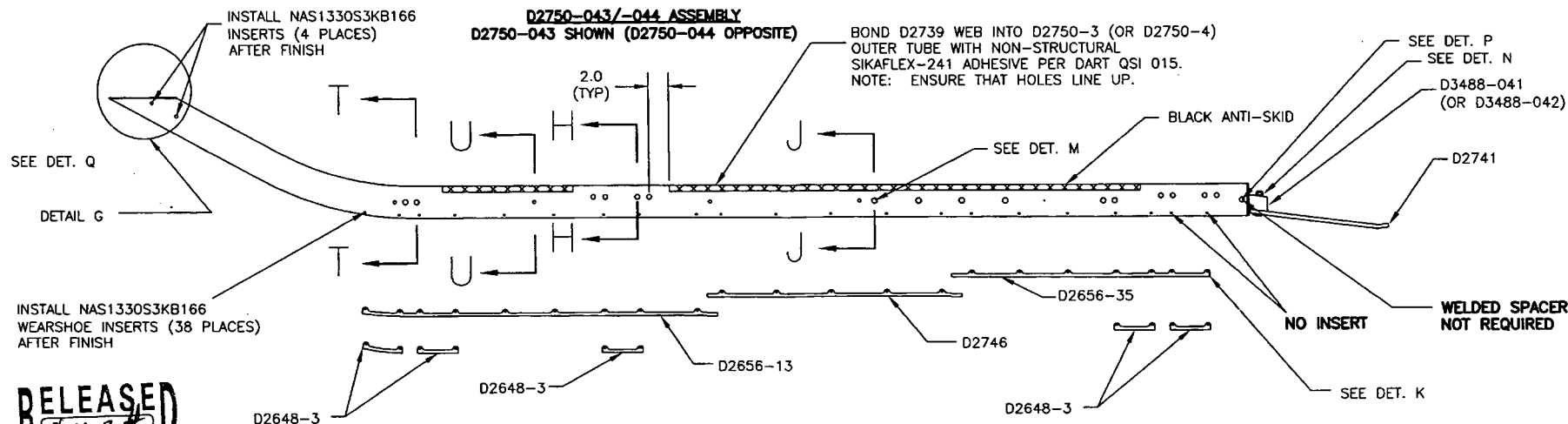
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| DATE<br>06.01.05                             |               | TITLE<br>350 SKIDTUBE ASSEMBLY |                | SCALE<br>1:20  |  |

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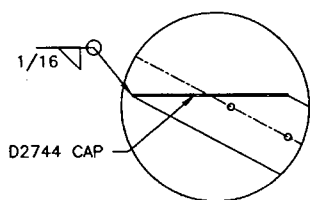
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**D2750-043/-044 ASSEMBLY**  
**D2750-043 SHOWN (D2750-044 OPPOSITE)**

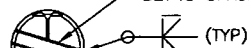
BOND D2739 WEB INTO D2750-3 (OR D2750-4)  
OUTER TUBE WITH NON-STRUCTURAL  
SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.



DETAIL G



SECTION H-H D2743 SPACER (REF)



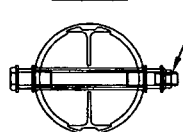
SECTION J-J



**WELDING INSTRUCTIONS**

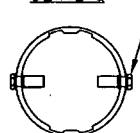
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

DETAIL M



- AN6C44A BOLT (1)  
D2745 BUSHING (2)  
NAS1515H8L WASHER (2)  
MS21043-6 NUT (1)  
(4 PLACES)  
NOTE: INSTALL WASHER BETWEEN  
SKIDTUBE AND BUSHING

DETAIL Q



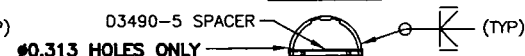
- AN3C6A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(4 PLACES)

SECTION T-T



D3492-041 PLUG ASSEMBLY

SECTION U-U

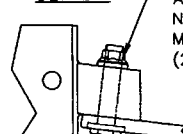


D3492-045 PLUG ASSEMBLY

**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS

DETAIL N



- AN8C21A BOLT (1)  
AN960JD816L WASHER (1)  
NAS1515H8L WASHER (1)  
MS21083C8 NUT (1)  
(2 PLACES)

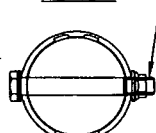
DETAIL K



- USE AN3C7A BOLTS  
FOR INSTALLING AFT  
D2648-3 WEARPAD  
(4 PLACES)

- AN3C5A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(38 PLACES)

DETAIL P



- AN8C35A BOLT (1)  
AN960C816L WASHER (2)  
NAS1515H8L WASHER (2)  
MS21083C8 NUT (1)

|  |               |                                |                |  |  |
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